

Work Order ID 52026

September 14, 2009 7:12:51 AM

Page 1

Item ID: D2622-120C

Accept

Revision ID: C1

Item Name: Step Extrusion

Setup Start

Stop

Start Date: 9/14/09 Start Qty: 121.00

Required Date: 9/30/09 Req'd Qty: 121.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *09/09/14* Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2622

Rev C1

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: *10390* (a) Extrude as per Dwg D2622 Rev. C1 (b)
Material: 6061-T6 (QQ-A-200/8) (c) Minimum yield tensile strength = 35
ksi (d) Minimum ultimate tensile strength = 38 ksi (e) Minimum elongation =
8% (f) Order at 120" longg) Bon L Canada Inc.

CL 09/09/14 121

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

09/9/23 112

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2622 for compliance page attached Check hardness
with Webster tester

27 S on 11/23

counted
(712) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52026

September 14, 2009 7:12:51 AM



Page 2

Item ID: D2622-120C

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Step Extrusion

Start Date: 9/14/09 Start Qty: 121.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 121.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: ~~6214~~

0.00



Packaging

Memo

0.00

Packaging

SAO

09-09-23

112

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/24 HJ
MF 09-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 14, 2009 7:12:50 AM

Work Order ID: 52026

Parent Item: D2622-120CRevC1

Parent Item Name: Step Extrusion

Comments:

Component Item ID/
Item Name

Replacement
Item ID

Mfg/
Purch

Bin
Item

Primary
Location

Last
Location

Route
Seq ID

Unit of
Measure

Qty on
Hand

Remaining
Qty To Pick

Qty
Issued

Date
Issued

Status

D2622-120CPRevC1

Purchased

No

110

Each

0.0000

121.0000

Extrusion



Start Date: 9/14/09

Start Qty: 121.00

Required Date: 9/30/09

Required Qty: 121.00



9/14/09 (112)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

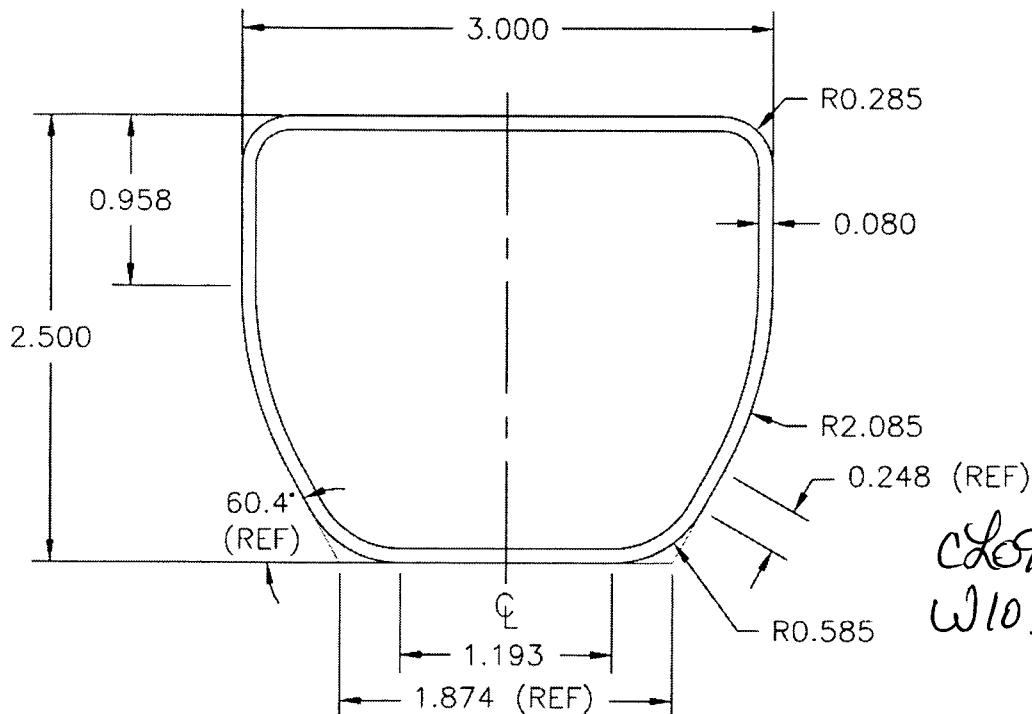
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




DESIGN KE	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	02.10.04	ADD 'REV. A' TO DIE NUMBER	



CL 09/09/14
W10:52026

D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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ACCT# 00046024

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

MANIFEST DATE	09-19-09
MANIFEST NUMBER	668193
SALES ORDER NUMBER	55161

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCECREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

LOCATION	TRAILER NUMBER	SALESMAN
RIH	QUE	59358

FIELD SALES REP
Kutter A
450-435-6551CUST SERVICE REP
Burton D
905-427-2227SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNSOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNTERMS / FREIGHT
O / P

PHONE 613-632-5200

PHONE 613-632-5200

CUSTOMER ID	ORDER DATE	CUSTOMER PO NUMBER
46024	09/14/09	10390

JOB

BILL OF LADING NUMBER
08399060

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
					LENGTH CUTTING TOLERANCE	FABRICATION DESCRIPTION SHIPPING TOLERANCE	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	1104	LF	0	DAA-897123-1	6061 /T6	MILL	2	1085	1049	LB	0
	1210	FT	0	D2622	120"	CERTIFICATE OF COMP			1119.99	FT	0
	121	PC	0		+3/16 "	(+015-015, 0139-0102)			112	PC	0
				LOT/TKT DETAIL:	-0 "		1	542	525		56 PC
						55161010 / 219605	1	542	525		56 PC
						55161010 / 219606	1	542	525		
							2	1085	1049	LB	
									1119.99	FT	
									112	PC	
							TOTALS				

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

DATE OF DELIVERY

DRIVER

EXTMAN2 CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10390

Purchase Order Date 9/14/09

PO Print Date 9/14/09

Page Number 1 of 1

Order From :

VC-BON001



SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name
Vendor Phone 800 563 1079
Vendor Fax 800 565 8339
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2622-120CP C1	Extrusion	9/30/09 Yes	121.00 Each	Yours ppd	\$23.7570	\$2,874.60

Special Inst: EXTRUDE AS PER DWG D2622
REV. C1
MATERIAL: 6061-T6 (QQ-A-200/8)
MINIMUM YIELD TENSILE
STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%
120" LONG
BON L CANADATOOL: # 897123
B52026

PO Total: \$2,874.60

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 9/14/09

CL
[Signature]

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable